

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016617**Date Inspected:** 14-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment 9EE ~ 10AE

This QA Inspector performed dimensional Joint Inspection with Caltrans (CT) QA Mr. Manjunath Math, for the U-rib to U-rib offset (Cross Beam side) and (Counter Weight side) for Segment 9EE to 10AE between Panel Point (PP) 85 and PP 86. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Closed Rib Stiffener Offset". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment 9EW ~ 10AW

This QA Inspector performed dimensional Joint Inspection with Caltrans (CT) QA Mr. Manjunath Math, for the

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T-rib to T-rib Horizontal and Vertical offset (Cross Beam side) and (Counter Weight side) for Segment 9EW to 10AW between Panel Point (PP) 85 and PP 86. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: WT Stiffener Offset / Transverse Segment Splice". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP160-001-047; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached photo.

Segment # 9DW ~ 9EW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9A-008; The Critical Welding Repair Report (CWRR) was B-CWR1679. ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345- SMAW 4G (4F) FCM-Repair -1.

Segment # 9DW ~ 9EW

This QA inspector observed, ZPMC qualified welding personnel identified as 040704 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG055C-045; ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132. See the attached photo.

Segment # 9DW ~ 9EW

This QA inspector observed, ZPMC qualified welding personnel identified as 040609 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG055B-043; ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2234-TC-U4c-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer